

13

Date: Thursday, 3/13/2008 1:01:33 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B AFT X-TUBE  
 Job Number : 37985  
 Estimate Number : 13221  
 P.O. Number :  
 This Issue : 3/13/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D206667201TRN  
 First Issue : / / Type : LANDING GEAR Drawing Number : D206-667-241 REVB  
 Previous Run : 37984 Project Number : N/A  
 Material : B  
 Due Date : 3/28/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 08 03 13  
 Comment : Est Rev:A 08-03-06 new issue DD verified by:ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

D6003102

Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D6003-102

Crosstube

Check OD = 2.250"; ID = 1.380"

B23967

08.04.03

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA084

2-Turn first side as per Folio FA084

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

08.04.03 (1)

3.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

08.04.03

(1)

4.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA084

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

3-Remove sand and plugs

08.04.03

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 3/13/2008 1:01:33 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 37985

Part Number: D206667201TRN

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-241  
Inside of Cuff(Donot engrave on outside of tube)

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BF 08-04-03

(1)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BF 08/04/03

(+1)

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

BF 08/04/07

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BF 08/04/07 (IX)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BT 08-04-07

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in kanban rack

Location: X tube comban (turn)

BT 0804-07

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion



MF 08-04-08

V

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>37985</b>
<b>Description:</b> Crosstube Assembly	<b>Part Number:</b>	<b>D206-667-241</b>
<b>Inspection Dwg:</b> D206-667-241 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	30° x 0.500	+/-0.010	.500	✓			
	0.250	+/-0.010	.250	✓			
	2.240	+0.005/-0.000	2.244	✓			
	4.438	+/-0.030	4.438	✓			
	1.780	+0.005/-0.000	1.784	✓			
	R0.063	+/-0.010	R0.063	✓			
	1.851	+0.005/-0.000	1.853	✓			
	1.928	+0.005/-0.000	1.931	✓			
	2.005	+0.005/-0.000	2.007	✓			
	2.082	+0.005/-0.000	2.085	✓			
	2.159	+0.005/-0.000	2.162	✓			
	2.190	+0.005/-0.000	2.193	✓			
SIDE B	30° x 0.500	+/-0.010	.500	✓			
	0.250	+/-0.010	.250	✓			
	2.240	+0.005/-0.000	2.244	✓			
	4.438	+/-0.030	4.438	✓			
	1.780	+0.005/-0.000	1.784	✓			
	R0.063	+/-0.010	R0.063	✓			
	1.851	+0.005/-0.000	1.853	✓			
	1.928	+0.005/-0.000	1.931	✓			
	2.005	+0.005/-0.000	2.007	✓			
	2.082	+0.005/-0.000	2.085	✓			
	2.159	+0.005/-0.000	2.162	✓			
	2.190	+0.005/-0.000	2.192	✓			
	100.60	+/-0.020	100.61				

<b>Measured by:</b>	<b>BK</b>	<b>Audited by:</b>	<b>HMM</b>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	<b>08.04.03</b>	<b>Date:</b>	<b>08/04/03</b>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue (P/O D206-667-201)	KJ/JLM	BK



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-667-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (206B HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05-06-16 [Signature]

Qty	Part Number	Description
X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
1	D6003-102	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
4	MS21920-20	CLAMP

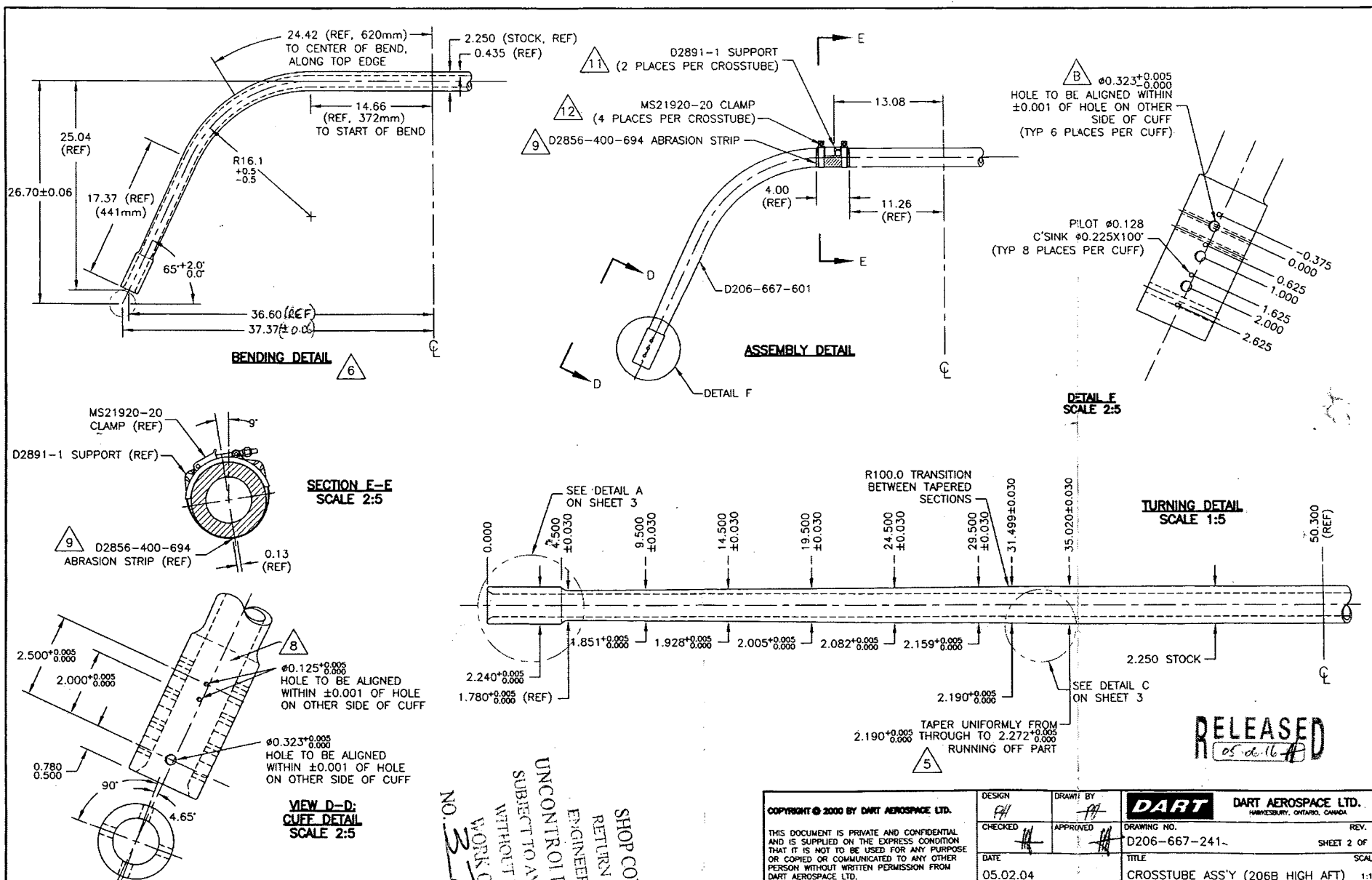
#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6003-102  
FINISHED LENGTH =  $100.60 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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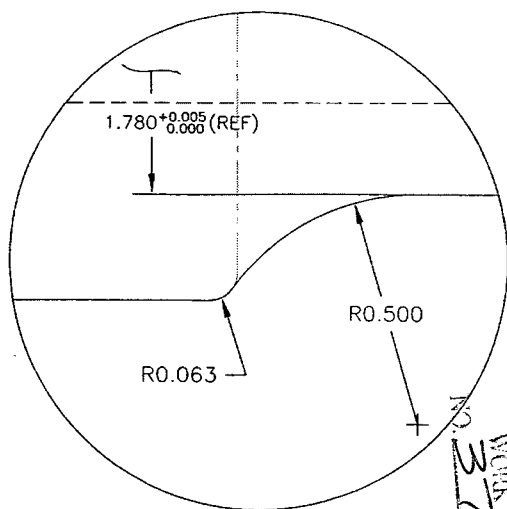
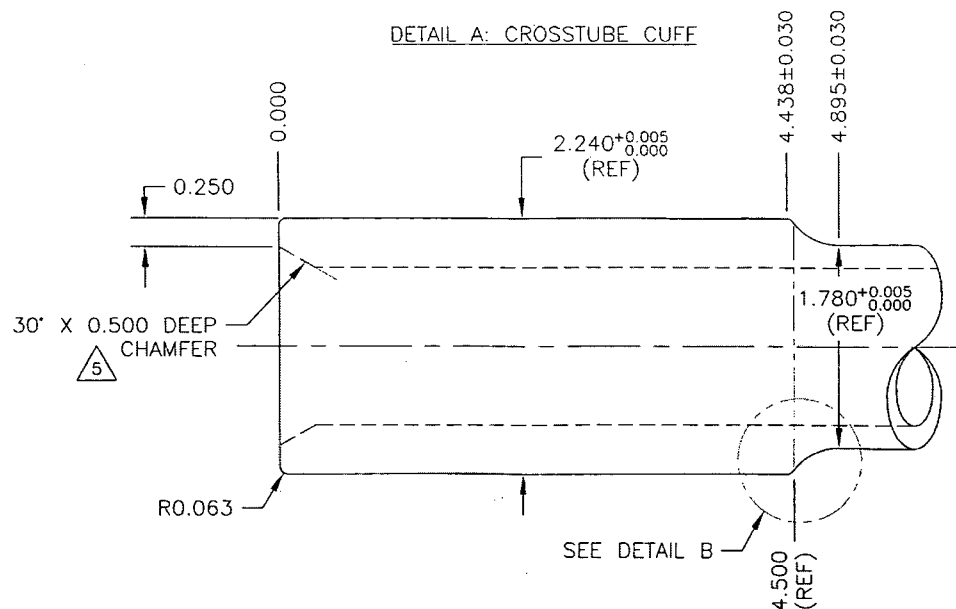


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		DATE		D206-667-241		SHEET 2 OF 3	
		05.02.04		TITLE		SCALE	
				CROSSTUBE ASS'Y (206B HIGH AFT)		1:10	

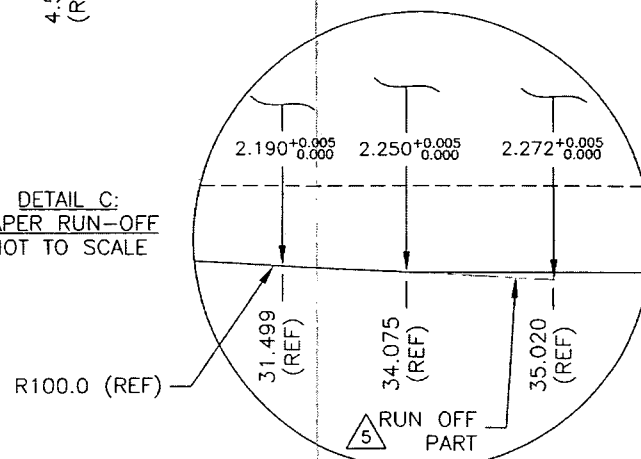
RELEASED  
05-06-16

DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF  
TRANSITION  
SCALE 4:1

DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



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CHECKED	#	APPROVED	#	DRAWING NO.	D206-667-241
DATE	05.02.04	TITLE	CROSSTUBE ASS'Y (206B HIGH AFT)	REV. 8	SHEET 3 OF 3
		SCALE	1:1		



